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D4961-043
Job Sheet 184001



Part No: D4961-043

Job Qty: 10 ea

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Small Fab-4		SmB
110	Small Fab	10 pcs	10/26/18	10/26/18	0.00	6.23	Small Fab-8		SmB
120	QC	10 pcs	10/26/18	10/26/18	0.00	0.00	QC5		38
130	Packaging	10 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-2		9-89
140	QC21-SA	10 Ea	10/26/18	10/26/18	0.00	0.00	QC21		21

Part Op 110 - 1- Cut D4961-3 tube to size as per dwg 2- On one side of tube flare end as per dwg then slide sleeves and nuts, Descriptions: flare other side of tube as per dwg.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN818-L12J	Nut	20 Ea (2 ea)	90-Start up Operation	5112883X6
M304TR0.750W.049	304 Round Tube .750 X .049W	2.5000 ft (.25 ea)	90-Start up Operation	5108841
MS20819-12J	Sleeve	20 Ea (2 ea)	90-Start up Operation	5107743

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN818-L12J	20	8	0
	M304TR0.750W.049	3	158	0
	MS20819-12J	20	52	0



Container No: S119349



Part: D4961-043

Job No: 184001

Serial No/Batch: S119349

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/18/18

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2:38 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					